

Work Order ID 60472

Monday, July 12, 2010 1:17:02 PM

Page 1

Item ID: D4016-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Half, Base

Start Date: 7/12/2010 Start Qty: 9.00

Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 9.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-7-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.00" LONG

0.00

MUC
10/09/23

9 0

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV: 1A

DWG REV: 1A

DEBURR

0.00

DJT 10/07/26

9 0

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 60472

Monday, July 12, 2010 1:17:02 PM



Page 3

Item ID: D4016-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half, Base

Start Date: 7/12/2010 Start Qty: 9.00



Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 9.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/27 J
10-7-26
(9)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Monday, July 12, 2010 1:17:06 PM

Page 1

Work Order ID: 60472



Parent Item: D4016-1



Parent Item Name: Hinge Half, Base

Start Date: 7/12/2010

Required Date: 7/16/2010

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304B1.500X1.500 | | Purchased | No | | | 100 | f | 9.6263 | 0.08 | 0.757895 | | | |

304 bar 1.50 X1.50

Location

Loc Qty

Loc Code

MAT54

9.62630368

108381

8.9682

112752

0.65810368

ms
10/07/23

7875

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|--------------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 60472 |
| Description: Hinge Half, Base | | Part Number: D4016-1 |
| Inspection Dwg: D4016 | Rev: A | Page 1 of 1 |

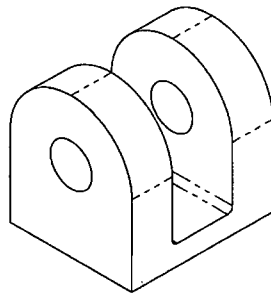
FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.875 | +/-0.010 | 0.876 | ✓ | | Vern | DTP-11 |
| 0.25 | +/-0.030 | 0.239 | ✓ | | Vern | DTP-11 |
| 0.38 | +0.030/-0.000 | 0.395 | ✓ | | Vern | DTP-11 |
| R0.03 | +/-0.030 | 0.03 | ✓ | | Rad gage | |
| 0.13 | +/-0.030 | 0.125 | ✓ | | Vern | DTP-11 |
| 0.88 | +/-0.030 | 0.877 | ✓ | | Vern | DTP-11 |
| Ø0.257 | +0.006/-0.001 | 0.259 | ✓ | | Vern | DTP-11 |
| R0.38 | +/-0.030 | 0.38 | ✓ | | Rad Gage | |
| 0.500 | +/-0.030 | 0.498 | ✓ | | Vern | DTP-11 |
| 0.75 | +/-0.030 | 0.752 | ✓ | | Vern | DTP-11 |
| | | | | | | |
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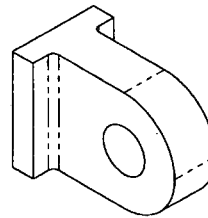
| | | |
|-------------------------|--------------------------------|------------------------------|
| Measured by: DTA | Audited by: [Signature] | Preliminary Approval: |
| Date: 10/07/26 | Date: 10/07/26 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|----------------|-------------|
| A | 10.06.07 | New Issue | KJ [Signature] | [Signature] |

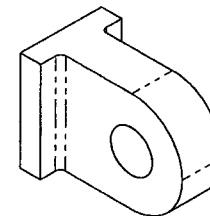
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 60972
BS10-7-12



D4016-1 HINGE HALF, BASE



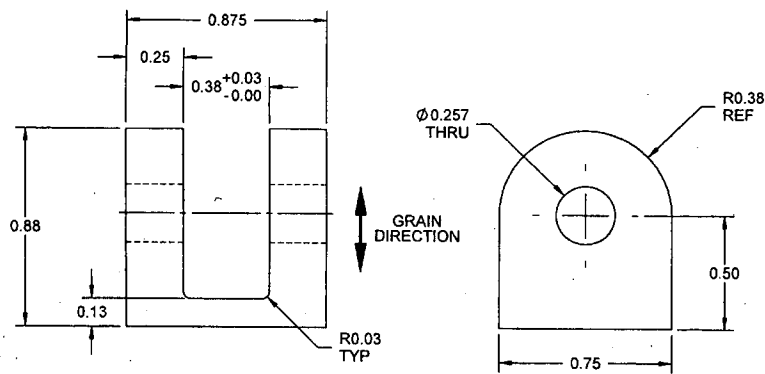
D4016-3 HINGE HALF, LID



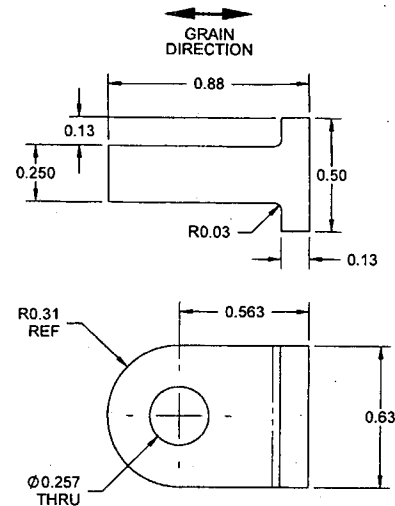
D4016-5 HINGE HALF, LIGHT LID

RELEASED
 2010-02-16
MP

| | | | |
|------------|-------------|---|--------------|
| A | NEW ISSUE | JPH | 10.01.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>GP</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>BS</i> | D4016 | SHEET 1 OF 2 |
| APPROVED | <i>MP</i> | TITLE | SCALE |
| DE APPR. | <i>MP</i> | BASKET HINGE | NTS |
| DATE | 10.01.29 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

alo 60472

RELEASED
2010-02-16
AM

| | | | |
|------------|--------------------|--|--------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D4016 | REV. A |
| MFG. APPR. | <i>[Signature]</i> | SHEET 2 OF 2 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | BASKET HINGE | NTS |
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